

# Work Order ID 55353

January 13, 2010 1:49:01 PM



Page 1

Item ID: D3805-043

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly Fwd, High Gear

Stop



Start Date: 1/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 1/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *ME*

Date: *10-1-13* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3805	Rev A
-------	-------

100

0.00



Large Fab

Memo

0.00

1- on D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805  
2059 B Hardcoat Welding Rod  
BATCH#: *M113521*

2-weld D3806-3 to wearplate by positioning holes together as per dwg D3805  
304 S.S. Welding Rod  
BATCH #: *M102421*

3-Transfer drill holes in bar

*EL 10-1-14* *(2)*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*PD 10.01.14* *(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/10/14



QC

Memo

0.00

(X2)

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

0.00

⇒ M 10/01/14

Powder Coating

Memo

START TIME: 10:00AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 10:30AM

XZ

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

bf 10-01-15

(2) φ.

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 55353

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Item ID: D3805-043

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Setup Start



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Item Name: Wearplate Assembly Fwd, High Gear

Stop



Start Date: 1/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 1/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00



Small Fab

Memo

0.00

1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m  
1300/1300L scotch grip adhesive as per dwg  
BATCH: M11B174

*ES 10/01/18* (2)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*2> 8 206.1.19*

(x2)

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*16-1-19*

*(2) SQ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 55353**

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Item ID: D3805-043

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Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 1/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 1/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/20 JF  
MF 10-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 55353

Parent Item: D3805-043

Parent Item Name: Wearplate Assembly Fwd, High Gear

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verified by:EC

Start Date: 1/13/2010

Required Date: 1/19/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3805-3		Manufactured	No			100	Each	5.0000	2.0000			
											EL	10-1-14
Plate												

Warehouse  
Location

Main Warehouse

ST


5

46930

1

52853

4

D3806-3		Manufactured	No			100	Each	4.0000	2.0000			
											EL	10-1-14
Bar												

Warehouse  
Location

Main Warehouse

WA

4

52852

4

D3807-3		Manufactured	No			150	Each	5.0000	2.0000			
											Ep	10/01/18
Gasket												

Warehouse  
Location

Main Warehouse

ST

5

52836

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

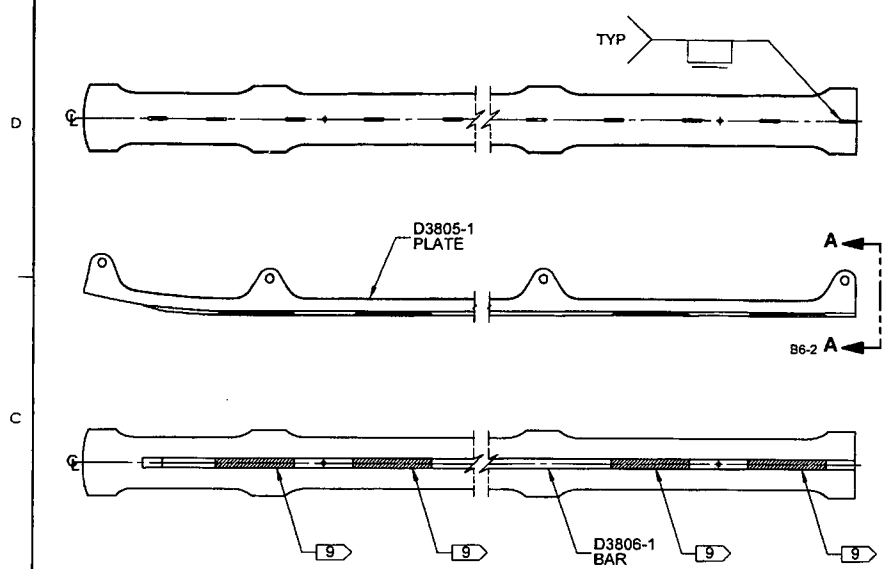
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

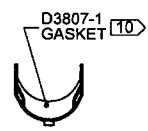
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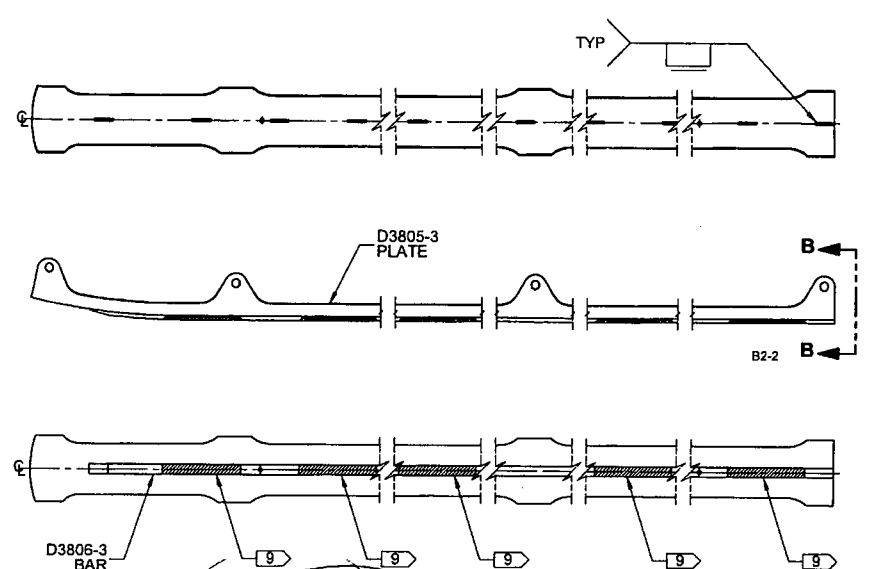
8 7 6 5 4 3 2 1



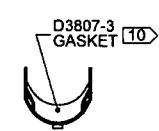
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**VIEW A-A** C5-2



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



**VIEW B-B** C1-2

#55353

**RELEASED**  
09.09.07

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	19	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	15	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 2 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALITY TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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